

Work Order ID 51291

August 15, 2009 8:12:31 AM



Page 1

Item ID: D205-770-011

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Engine Mount

Start Date: 08/24/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MUF Date: 09-08-15

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr ~

Revision Nbr

IIN D205-770

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D205-770-011 CHG001

Sorlos

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

P-4/9/15 (2)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

=> Sorlos

(2) p

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC,Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-770-011 CHG001 Location: _____ PPP Rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/9/16 (Jx) SP

09/09/16 HJ

B/ 09-9-16

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 51291

Parent Item: D205-770-011RevB

Parent Item Name: Replacement Engine Mount

Comments:

Start Date: 08/24/2009

Required Date: 08/28/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3684-043RevC 1P Manufactured No

110

Each

1.0000

2.0000

✓



MOUNT ASSEMBLY

8/19/10 (2)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

50719

1

110

Each

2.0000

2.0000

✓

D3684-045RevC 1P Manufactured No



LEG ASSEMBLY

8/19/10 (2)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

50739

2

Main Warehouse

ST139A

4

B 47875

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 2

August 15, 2009 8:12:31 AM

Work Order ID: 51291



Parent Item: D205-770-011RevB



Parent Item Name: Replacement Engine Mount

Start Date: 08/24/2009

Required Date: 08/28/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3692-1RevB <i>yp</i> SPACER		Manufactured	No			110	Each	107.0000	8.0000 ✓			

8/18/09 (2)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 107

44827 8

45672 14

50325 85

Main Warehouse

ST127 161

B 50736

AN3C12A *yp*

Purchased

No

110

Each

547.0000

8.0000 ✓



Bolts

8/18/09 (2)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 547

106993 7

110155 2

110552 3

110584 45

111916 20

112314 470

Q

m 112314

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

August 15, 2009 8:12:31 AM

Work Order ID: 51291

Parent Item: D205-770-011RevB

Parent Item Name: Replacement Engine Mount

Comments:

Start Date: 08/24/2009

Required Date: 08/28/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21043-3 2P

Purchased

No

110

Each

5,488.000

4.0000 ✓



Nut

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

5408

111819

124

112243

300

112314

4984

M112243

D3685-041RevC 1P

Manufactured

No

110

Each

0.0000

2.0000 ✓



BIPOD MOUNT ASSEMBLY

D3686-041RevC 1X

Manufactured

No

110

Each

3.0000

2.0000 ✓



MONOPOD ASSEMBLY

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

51157

3

Main Warehouse

ST139

5

51157

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-770-011	14.6 lb	-3.5 in	-51.1 in-lb	107.8 in	1574 in-lb
Replacement Engine Mount Kit	6.62 kg	-0.09 m	-0.6 m-kg	2.74 m	18.1 m-kg

5. PARTS LIST

Qty -011	Part Number	Description
X	D205-770-011	REPLACEMENT ENGINE MOUNT KIT
1	D3684-041	TRIPOD MOUNT ASSEMBLY
1	*D3684-043	MOUNT ASSEMBLY
8	**D3692-1	SPACER
4	**AN3C-12A	BOLT
4	**MS21043-3	NUT
1	**D3687-1	MOUNT
1	**D3684-047	FWD LEG ASSEMBLY
1	***D3688-1	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	**D3684-049	AFT LEG ASSEMBLY
1	***D3688-3	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	*D3684-045	INBOARD LEG ASSEMBLY
1	**D3688-5	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
4	*D3692-1	SPACER
2	*AN3C-12A	BOLT
2	*MS21043-3	NUT

5/29/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1	D3685-041	BIPOD MOUNT ASSEMBLY
1	*D3687-3	MOUNT
1	*D3684-047	FWD LEG ASSEMBLY
1	**D3688-1	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
1	*D3684-049	AFT LEG ASSEMBLY
1	**D3688-3	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
8	*D3692-1	SPACER
4	*AN3C-12A	BOLT
4	*MS21043-3	NUT
1	D3686-041	MONOPOD ASSEMBLY
1	*D3688-7	STUD
1	*D3689-1	SLEEVE
1	*D3691-1	STUD
4	*D3692-1	SPACER
4	*D3692-3	SPACER
1	*D3693-1	ROD END BEARING
1	*D3693-3	ROD END BEARING
2	*AN3C-10A	BOLT
2	*AN3C-12A	BOLT
4	*MS21043-3	NUT
1	*NAS509-12C	NUT
1	*NAS509L-12C	NUT

(NOTE: PARTS IN BOLD TYPE CONSTITUTE PICK LIST FOR D205-770-011 KIT)

* PART IS INCLUDED WITH ASSEMBLY ABOVE

** PART IS INCLUDED WITH ASSEMBLY ABOVE

*** PART IS INCLUDED WITH ASSEMBLY ABOVE

5/26/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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